Work Order ID 95283

Thursday, January 24, 2013 12:00:20 PM

95283

Item ID:

D3137-043

Accept

N900040100

Setup Start

Revision ID:

Item Name: Bracket Assembly

Start Date: Required Date: 1/8/2013

1/7/2013

Start Qty: 2.00 Req'd Qty: 2.00

Cust Item ID:

Customer:

CU-DAR001

Reference:

Approvals:

RMA RA111456 C MW

Process Plan:

Date:

Tooling:

Date:

Run

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

Operation

Set Up/

Tool ID

Tool # Plan

Reject Accept Qty

Insp.

Description

Run Hours

Code

Qty

Reject

Number Stamp

Draw Nbr

Revision Nbr

D3137

Rev F

100

100 QC

Quality Control

Memo

INSPECT RA 111456

D3137-043 X B89467 B 85867

PART ARE GOOD

*OLD BATCH NUMBER NEEDS TO BE BUFFED AND NEW BATCH

NUMBER SCRIBBED ON*

110

110

Small Fab Small Fab

0.00

Memo

0.00

BUUF OUT OLD BATCH NUMBER

SCRIBE NEW BATCH NUMBER IN SAME LOCATION

							•					DQA:	Date	•			
NCR:	Yes	/ No					WORK ORDER NON-O	:01	NFOR	MANCE / UP	DATE						
						_						QA Closed:	Date	:			
Work Ord	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part I							Rework Scrap		Skid-tube Crosstube Machining Small Fab				Water Jet d. Eng. Coor.	Engineering Quality			
NCR I	Vo.						Use-as-is Work Order Update		Thermoforming Finishing Large Fab Composite			Rec/Stor	e/Packaging Supplier	Other			
Root					Des	crip	otion of work order update		nitial	Ac	tion	Sign &					
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector			
oc/Data quip/Tooling Operator Material etup Other rocess upplier training																	
								AUL	T CATE	GORY							
Landi		Ī			ſ		General	_	l		_	7	L	7			
		Bending Centre Not Concentric to O/S Cracks					Bend BOM/Route Broken/Damaged		Grain Hardware Inspection Incomplete			Ovalized Over/Under tolerance Part Incorrect		Pressure/Forced Temperature/Cure Weld			
		Crushed/0	Crimped.				Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/Missing		Wrong Stock Pulled			
		Cuffs					Contamination		Mainte	nance		Part Moved					
		Heat Trea	it				Countersink		Mislabe	led		Positioned Wrong		_			
		Inspection	n Strip in	Tube			Cut Too Short		Misread	1		Power Loss/Surge		Other			
		Ripples in	Bend				Drill Holes		Offset								
		Torque W	aves in E	xtrusion			Drawing		Out of (Calibration							
		Turning S	eguence				Finish	Out of	Sequence								

Outside Dimensions

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Wave/Twist in Tube

Folio



95283

Work Order ID 95283

Thursday, January 24, 2013 12:00:20 PM

Item ID:

D3137-043

Revision ID:

Item Name:

Bracket Assembly

Start Date:

1/7/2013

QC:

Start Qty: 2.00 Required Date: 1/8/2013

Reg'd Oty: 2.00

Accept

N900040100

Setup Start

Cust Item ID:

Customer:

CU-DAR001

Reference:

Approvals:

RMA RA111456

Process Plan:

Date: Date:

Tooling:

Date:

Run

Start

Stop

Sequence ID/ **Work Center ID**

120

QC5- Inspect part completeness to step on W/O

120

QC Quality Control Operation **Description**

Memo

Memo

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept

Insp.

130

130

Packaging Packaging

Identify as per dwg & Stock Location:

Std 36A

0.00

0.00

140

140

OC Quality Control QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

-13/1/ss Q

SPC (Y/N):

Date:

Qty

Reject Qty

Reject Number

Stamp

												DQA:	Date	:			
NCR:	Yes	/ No					WORK ORDER NON-	100	NFORM	MANCE / UPI	DATE		_				
												QA Closed:	Date	:			
Work Ord	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No.							Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other			
NCR	No.						Work Order Update	ا ل		Large Fab	Composite]	Supplier				
Root					Des	crip	otion of work order update		nitial	Act	tion	Sign &					
Cause		Date	Step	Qty		o	r Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector			
oc/Data quip/Tooling perator Material etup Other rocess upplier raining													`				
							F	AUL	T CATE	GORY							
Land	ing (1			1		General Bend					Tovalizad	Γ	Pressure/Forced			
		Bending Centre Not Concentric to O/S Cracks					BOM/Route Broken/Damaged		Grain Hardware Inspection Incomplete			Ovalized Over/Under tolerance Part Incorrect		Temperature/Cure Weld			
		Crushed/	Crimped,				Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled			
		Cuffs					Contamination		Mainte	nance		Part Moved	_				
		Heat Trea	it				Countersink		Mislabe	led		Positioned V	Wrong _	\neg			
		Inspection	n Strip in	Tube			Cut Too Short		Misread	1		Power Loss/Surge Ot		Other			
		Ripples in	Bend				Drill Holes	L	Offset								
		Torque W	aves in E	xtrusion	١		Drawing		Out of 0	Calibration							
		Turning S	eanence				Finish Out of Sequence										

Outside Dimensions

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Picklist Print

Thursday, January 24, 2013 12:00:20 PM

Work Order ID:

95283

Parent Item:

D3137-043

Parent Item Name:

Bracket Assembly

Comments:

IPP Rev:A04.02.18New issueKJ/DS

IPP Rev B 08.07.03 ECN1207 EC verified by DD

Start Date: 1/7/2013

Required Date: 1/8/2013

Page 1

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3137-043 Bracket Assembly		Manufactured	No				Each	6.0000		2			
				Location		Loc Oty	<u>Lo</u>	c Code					
				ST235A		6							
				7973	34	2							
				9406	54	4							

85867 x 2

												DQA:	Date:		
NCR:	Yes	/ No					WORK ORDER NON-C	100	VFOR	MANCE / UPDAT	ΓΕ	0.4.61	Data		
						_						QA Closed:	Date:		
Work Ord	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part I							Rework Scrap		Skid-tube Crosstube Machining Small Fab			+	Water Jet d. Eng. Coor.	Engineering Quality	
NCR	No.						Use-as-is Work Order Update		Thermoforming Finishing Large Fab Composite			Rec/Stor	e/Packaging Supplier	Other	
Root					Des	crip	otion of work order update	i	nitial	Action		Sign &			
Cause		Date	Step	Qty		O	r Non-conformance	Ch	ief Eng	Descripti	on .	Date	Verification	QC Inspector	
oc/Data															
quip/Tooling															
perator								İ							
Material								ļ							
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upplier	<u></u>	ļ													
raining															
Inapproved	<u> </u>	<u> </u>	<u> </u>					<u> </u>							
								AUL	T CATE	GORY					
Land	ing	7			ı		General		1			۱		Pressure/Forced	
	<u> </u>	Bending					Bend	\vdash	Grain			Ovalized	4-1		
	\vdash	Centre Not Concentric to O/S					BOM/Route	\vdash	Hardwa		-	Over/Under tolerance		Temperature/Cure Weld	
	\vdash	Cracks					Broken/Damaged	\vdash	4	ion Incomplete		Part Incorred	 		
	\vdash	Crushed/	Lrimped.				Burrs	\vdash	4	ions Incomplete/Uncl	ear	Part Lost/Mi Part Moved	22111R	Wrong Stock Pulled	
	-	Cuffs					Countarial	-	Mainte		-	-{	Vrong		
	_	Heat Trea		Tulka			Countersink	-	Mislabe		-	Positioned Wrong Power Loss/Surge		Other	
	\vdash	Inspection		rupe			Cut Too Short Drill Holes	\vdash	Misrea Offset	ı	<u> </u>	Trower ross/	Juige	Tottlei	
	-	Ripples in		Tyterinin -	_		1	-	4	Calibration					
	\vdash	Turning S			'		Drawing Finish	-	Out of Calibration						
	Turning Sequence														

Outside Dimensions

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RA111456

Received @ Dart January 3rd, 2013 Inspected@ Dart January 7th, 2013 Customer: VECTOR AEROSPACE Customer Contact: ALEX THIBAULT Shipped from: LANGLEY BC, CANADA

Instructions for RA 111456

- Parts returned are
 - o D3137-043 B83467 x3, B89427 x1, & B85867 x2
 - o D3183-043 B82688 x3
 - o D3183-044 B85996 x3
- Have instruction on all restocking work orders to buff out original B#'s and scribe in new ones in same location
- Needs new B#'s for restocking

<u>Time Estimate</u> = 3 HOURS (stores & small fab)

Departments Required: Stores & Small fab

 $\underline{Pictures\ Attached} = NO$

 $\underline{QTY \, INSPECTED} = \underline{QTY \, x6 \, D3137-043}$

QTY x3 D3183-043 QTY x3 D3183-044

THIS INSTRUCTION SHEET MUST BE ATTACHED TO THE RESTOCKING WORK ORDER AT ALL TIMES!!!!

											DQA:	Date:		
NCR:	\cdot													
								,			QA Closed:	Date:		
Work Order:										PROCESS				
Part N	•					Rework Scrap		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other	
NCR I	No.					Use-as-is Work Order Update]		 	Finishing Composite	Rec/stor	Supplier	Other	
Root					Descri	ption of work order update		nitial	Action	1	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descript	ion	Date	Verification	QC Inspector	
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quip/Tooling					:							•		
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upplier raining														
Inapproved														
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Landi	ng (Gear				General								
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre Not Concentric to O/S				BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	ct	Weld	
		Crushed/0	Crimped.			Burrs		Instruct	tions Incomplete/Und	lear	Part Lost/Mi	Wrong Stock Pulled		
		Cuffs				Contamination		Mainte	enance		Part Moved			
		Heat Trea	t			Countersink		Mislabe	eleć		Positioned V	Vrong	,	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other	
		Ripples in	Bend			Drill Holes		Offset						
		Torque W	aves in E	xtrusio	n 🗀	Drawing		Out of	Calibration					
		Turning Se	equence			Finish		Out of !	Sequence					
	Wave/Twist in Tube					Folio		Outside Dimensions						

